








Work Order ID 63549




Thursday, November 04, 2010 10:02:37 AM



Page 1

Item ID: D3066-1 Accept  Setup Start 
Revision ID: Stop 
Item Name: Spacer
Start Date: 11/4/2010 Start Qty: 80.00  Cust Item ID:
Required Date: 11/19/2010 Req'd Qty: 80.00  Customer:
Reference:

Approvals: Process Plan: H Date: 10-11-04 Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3066	Rev B								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3066								
6061.086	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

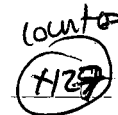
NOT PULLED

B10-11-8



B10-11-8

Scalping



Pro →

ASD015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3066-1 PAR #: Fault Category: Small fab/w-jet NCR: Yes No DQA: Date: 10-16-10
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 10/11/11

NCR: 63549		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/11/10	#100	Found qty x2 parts that moved during w/setting. one has hole location off center		→ SCRAP + Destroy no replace qty x2		10/11/10		
		- other has holes all elongated D.C. Parts moved. <u>Process.</u>						

NOTE: Date & initial all entries

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Accept

Revision ID:

Item Name: Spacer

Setup Start

Stop

Start Date: 11/4/2010 Start Qty: 80.00

Required Date: 11/19/2010 Req'd Qty: 80.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

STEVEN
PAT

0.00



Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

127 BR 10-10-10.

L 10/11/11 (127)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 3

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Item Name: Spacer

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Required Date: 11/19/2010 Req'd Qty: 80.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 10/11/11

PL 10-11-11

127

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Thursday, November 04, 2010 10:02:41 AM

Page 1

Work Order ID: 63549



Parent Item: D3066-1



Parent Item Name: Spacer


Start Date: 11/4/2010

Required Date: 11/19/2010

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP: ☐ C ☐ 02.11.01 ☐ Incorporated D3066-1 IPP ☐ KJ/RF
IPP Rev:B Now M6061-T6 06-06-23 JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080  6061-T6 .080 Sheet		Purchased		No		100	sf	10.7162	0.0945	7.957895	17.2	11-11-8	

Location

Loc Qty

Loc Code

MAT

10.715

115689

10.715

MAT21

0.0012

113438

0.0012

113438 X

13

W/O:		WORK ORDER CHANGES					
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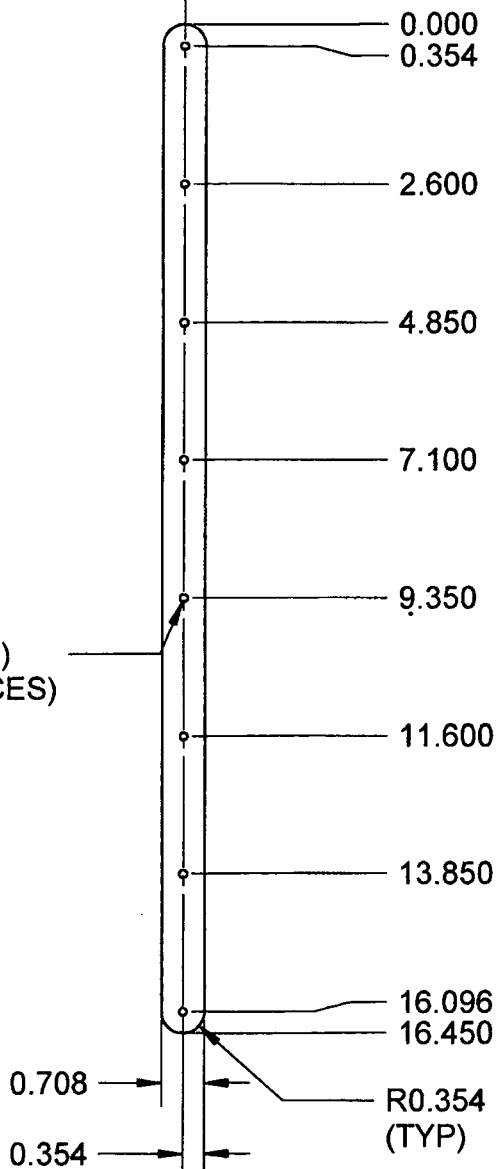


DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3066	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SPACER	SCALE 1:3
A	02.09.11	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED

de. de. 20 *[Signature]*

Ø 0.128 (#30)
(TYP 8 PLACES)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *63549*

BS10-11-04

D3066-1 SPACER

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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